

35

DART AEROSPACE LTD	Work Order:	21373
Description: Bushing	Part Number:	D2617-5
Dwg: D2617 Rev. D1	Qty:	24 29
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JA	04.08.23	24
2	MC	Machine as per Folio FA438 and Dwg D2617 Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.500" tubing x 0.058" wall (M6061T6T0.500W.058) Identify as D2617-5 Batch: 415483	SE	04/08/24	29
3	QC2	Inspect parts as they come off the CNC machine	SE	04/08/24	29
4	QC8	Second check	PO	04/08/25	29
5	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	SB	04/08/25	29
6	FP	Acid Etch and Alodine as per QSI 005 4.1	MM	04/08/25	29
7	QC5	Inspect work to Step 6	AB	04.08.25	29
8	ST	Identify and Stock	CJ	04/08/25	29
9	AC	Cost / part: 1.67	SUC	04.08.26	29
10	DC	Close W/O 3.29 Inspect Level 21	JA	04.08.26	29

Rev	Date	Change	Revised By	Approved
D	98.04.16	Re-Format	KB	
E	99.08.23	Re-format, added notes and inspection level	EC	
F	01.01.03	Re-format, made in-house	EC	
G	01.01.08	Updated material NCR 467	EC	
H	04.07.14	Reformat; added step 5	KJ/JLM	

RELEASED

04/07/14

Dart Aerospace Ltd

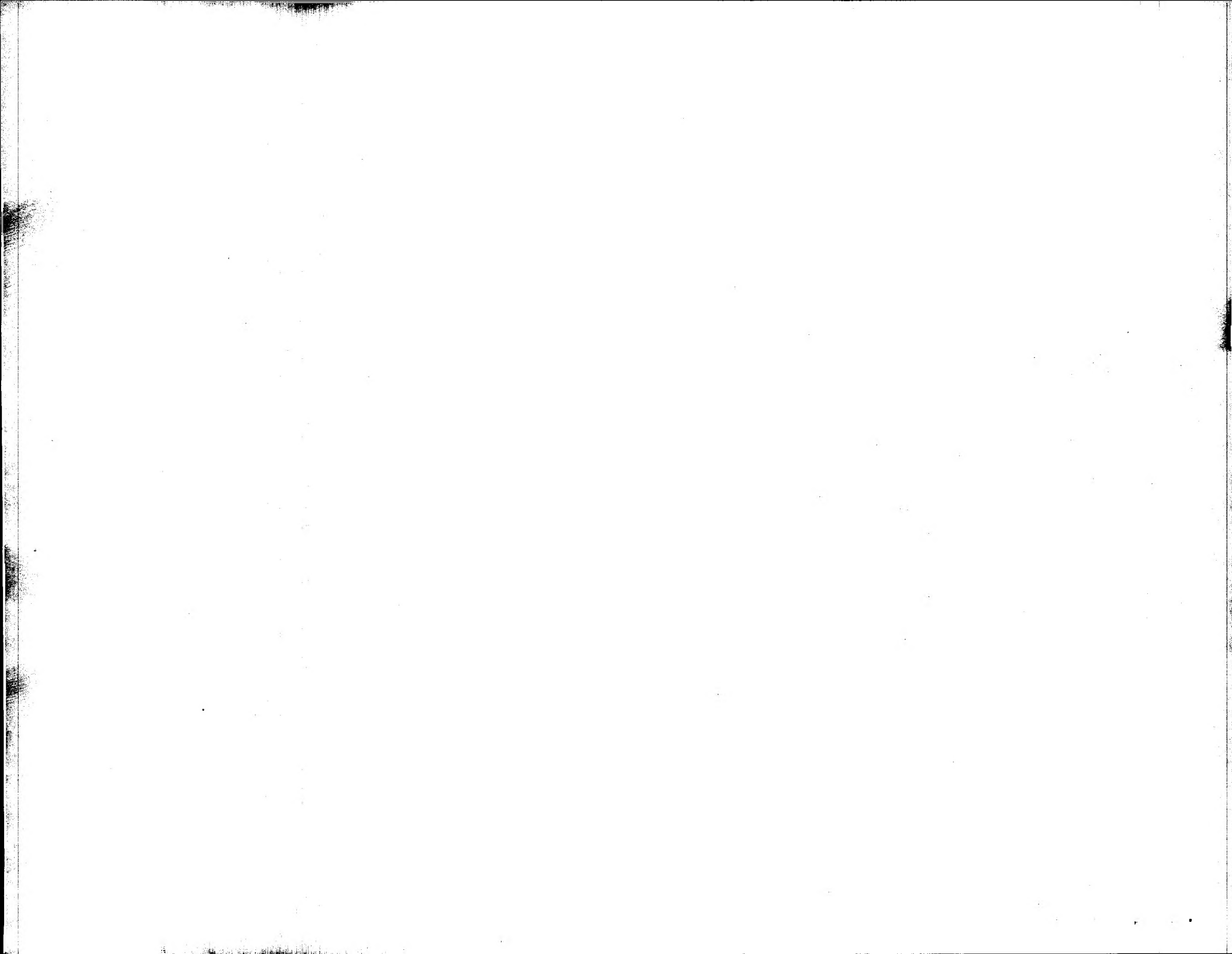
Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

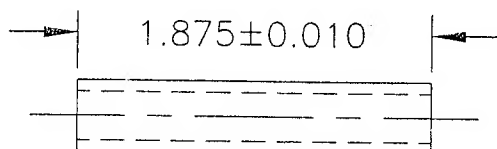
QA: N/C Closed: _____ Date: _____



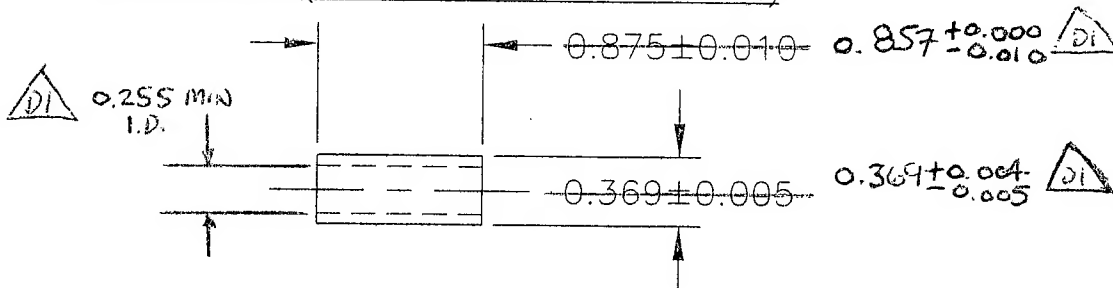


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. D
				D2617	SHEET 1 OF 1
DATE			TITLE		
01.07.04			BUSHING		
			SCALE		
			1:1		
A	96.10.08		NEW ISSUE		
B	97.05.08		.875 WAS 1.125		
C	97.06.04		0.369 DIA WAS 0.375		
D	01.07.04		ADD MAT'L SPEC AND TOL./DIM. NOTE		
DI	CP	04.07.12	CORRECT TOLERANCE (NCR 779)		

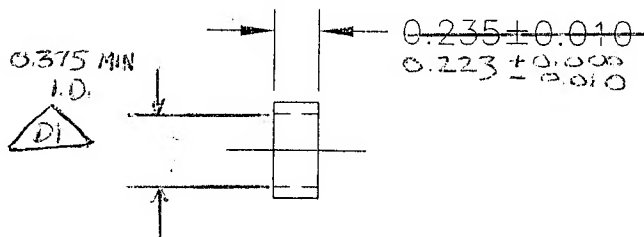
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 21373

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 23, 2004
09:50 am

Work Order No : 0021373
Project Name : D2617-5
Project For : WK435
Work Order Type : Main
Main WO Number :
House Part Number : D2617-5
Description : Spacer
Manufactured : Yes
Amount Req'd : 24
Amount Done : 0
Start Date : 08-20-04
Est Finish Date : 08-26-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00